

Date: Tuesday, 4/17/2007 11:05:36 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT		
Job Number	31838B					
Estimate Number	10462					
P.O. Number	N/A		Part Number	: D32782		
This Issue	4/17/2007 S.O. No. N/A		Drawing Number	: D3278 REV. B		
Prsht Rev.	NC		Project Number	: N/A		
First Issue	N/A		Drawing Revision	: B		
Previous Run	31736		Material	: N/A		
Written By			Due Date	: 4/24/2007 Qty: 30 Um: Each		
Checked & Approved By						
Comment	Est:A 0404.19 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.2454 f(s)/Unit Total : 7.3616 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
(M6061T6B1.000x02.000)

Batch: M104187

on 07/05/22 30

2.0	SHEAR SAW	SHEAR
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Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

on 07/05/22 30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Machine as per Folio FA405 and Dwg D3278
- 2- Deburr and Tumble
- Identify as D3278-2

on 07/05/24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

on 07/05/24

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

on 07/05/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/20

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/24	S.O	-1 part moved while machining. scrap	J Fasouri	- Replace & destroy again....	S.A. 07/05/24	J Fasouri	J Fasouri	J Fasouri

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 31838B

Part Number: D32782

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AS

07-05-28

(30)

7.0 POWDER COATING

POWDER COATING



M 103141

07/05/29 (30)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL / M

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

E 07/05/29 (30)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

E 07/05/29 (30)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

A 07/05/30

Job Completion



U 07.05.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31838B
Description: Support	Part Number:	D3278-2
Inspection Dwg: D3278 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø0.098	—			
0.359	+/-0.005	0.358	—			
0.615 0.609	+/-0.010	0.610	—			
0.250	+/-0.010	0.251	—			
1.480	+/-0.005	1.480	—			
R0.125	+/-0.010	R0.125	—			
0.119	+0.005/-0.004	0.123	—			
2.439	+/-0.010	2.440	—			
1.980	+/-0.010	1.980	—			
R0.130	+/-0.010	R0.130	—			
Ø0.257	+0.005/-0.000	Ø0.258	—			
R0.375	+/-0.010	R0.375	—			
0.875	+/-0.010	0.875	—			
0.500	+/-0.010	0.499	—			
R0.400	+/-0.010	R0.400	—			
1.720	+/-0.010	1.723	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.127	—			

Measured by:	Amel	Audited by:	SD	Prototype Approval:	N/A
Date:	07/05/23	Date:	07.06.24	Date:	N/A

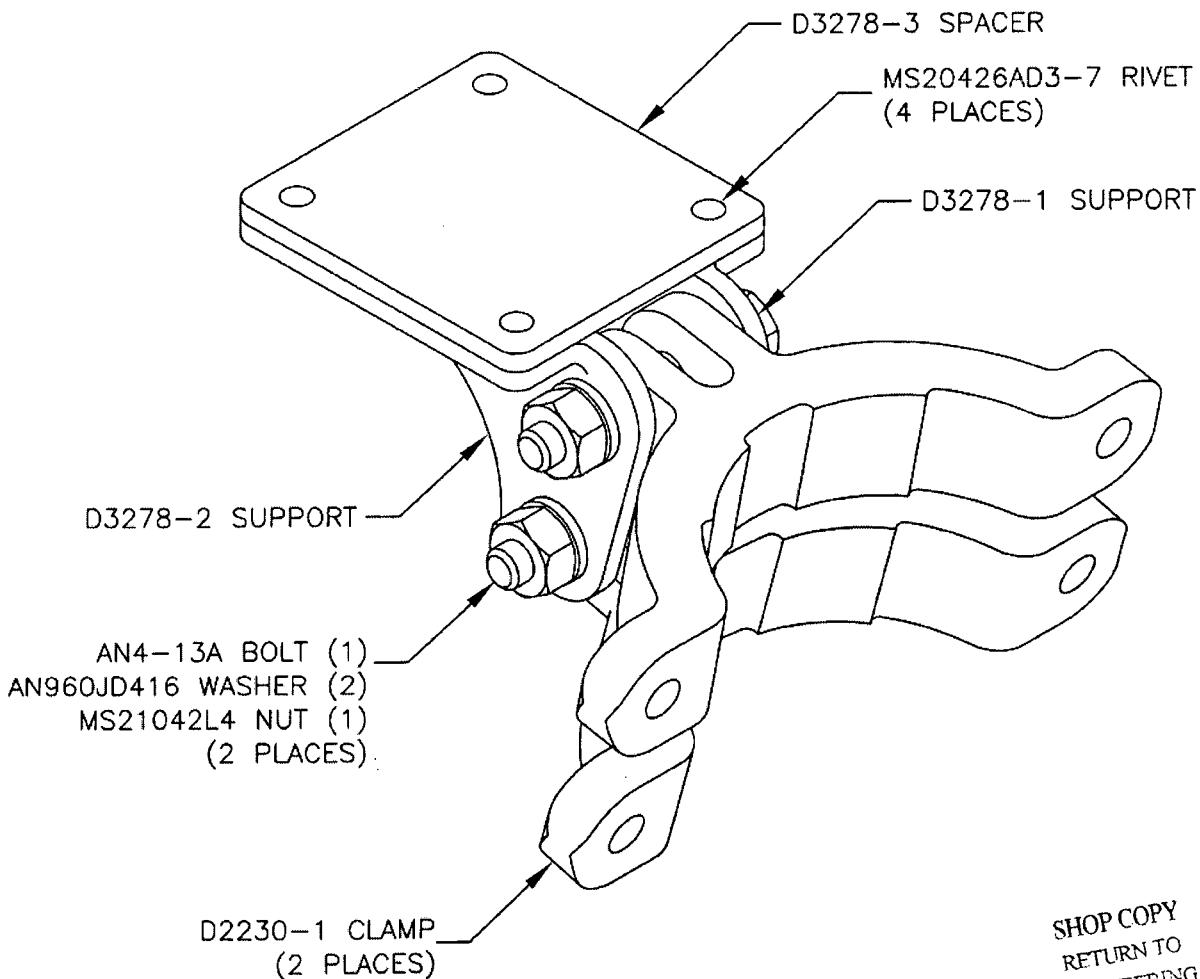
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	SD



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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04 *[initials]*

D3278-041 SUPPORT ASSEMBLY



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NO. *31838-B*

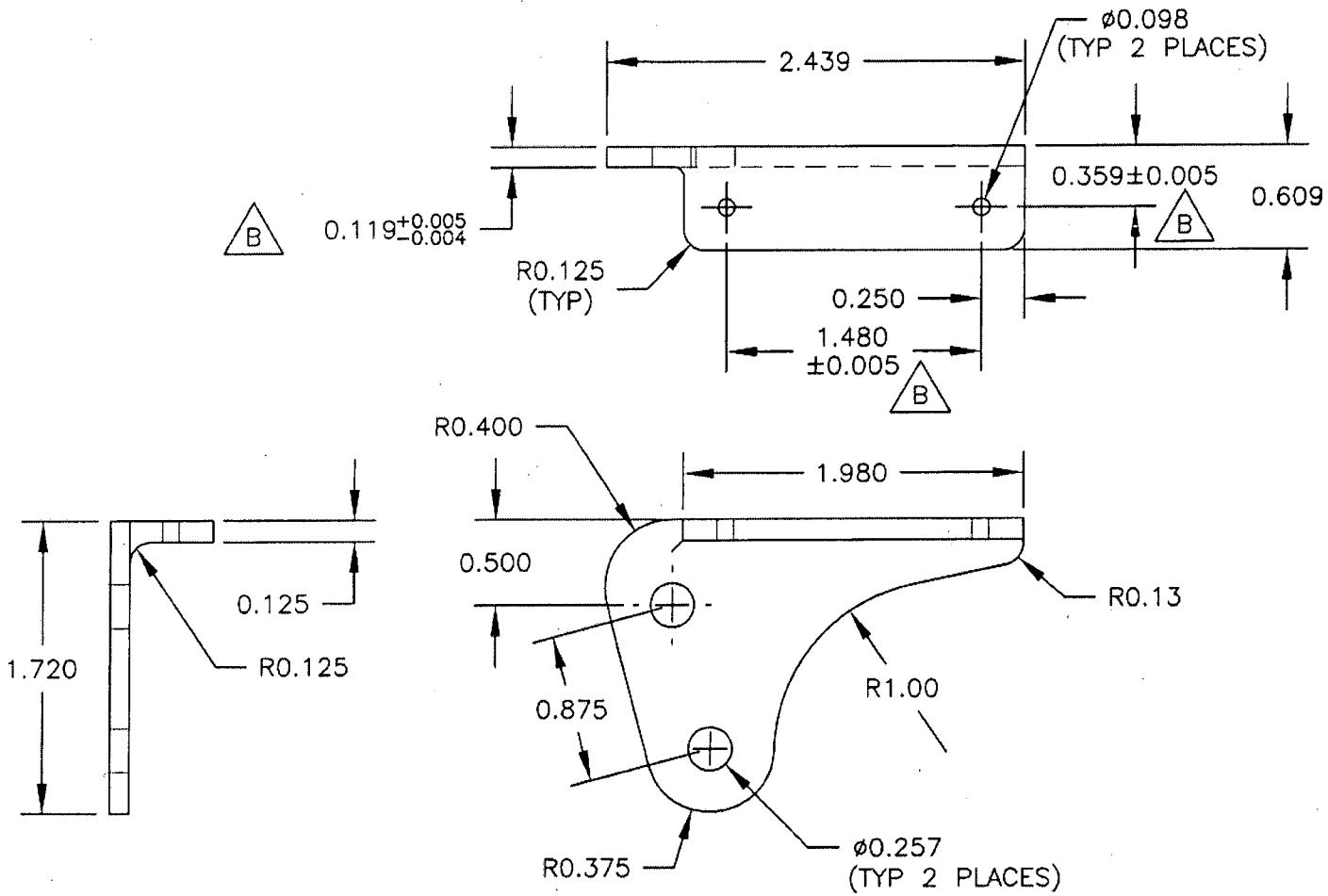
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY	REV. B SHEET 2 OF 3 SCALE 1:1

RELEASED

05.04.04 *[Signature]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRPT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11T6)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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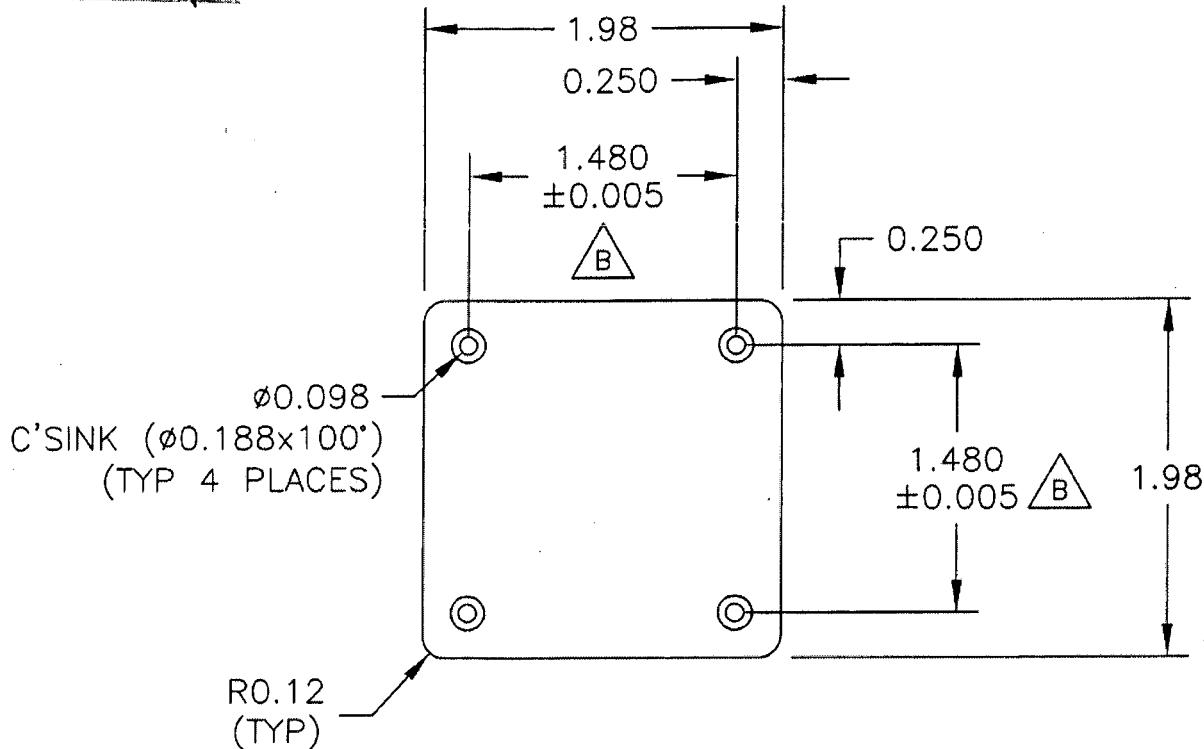
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY	REV. B SHEET 3 OF 3 SCALE 1:1

RELEASED

05.04.04 *[initials]*D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR 0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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